Worl	(Or	der	ID	73086
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Thursday, August 25, 2011 1:25:40 PM





Page 1

Thursday, Magus		J. 40 1 W		٧	· · · · · · · · · · · · · · · · · · ·				Ť		
Item ID: Revision ID:	D3264-1		A	Accept				s s	Setup Star	t iiiiiii	
	Bracket					÷.			Stop)	
Required Date:		Start Qty: 6.00 Req'd Qty: 6.00 £			Cust Item I Customer:	D:				7 124(1151 2	
Reference:								E	Run Star		
Approvals:	Process Plan	: Thu	Date: 11-08-25	Tooling:	Da	ıtė:		r			
	QC:		Date:	SPC (Y/N):	Da	ite:		•	Stop)	
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject ,	Reject Number	Insp. Stamp
Draw Nbr	Revis	ion Nbr									
D3264	Rev A	.2									
100 Bandsaw		Memo		0.00		E		<u></u>			
Jeaspa Bandsaw			C 5.700" LONG								
		g								•	÷ .
HAAS I	machine #1	Memo MACHINE A	AS PER FOILIO FA447	0.00 B.A	or Lillodo	7		6	K	· ·	
		FOLIO REV: DWG REV: DEBURR AS	AA	11/09/06/	:	•		×.			

W/O:	<u>-</u>			WORK ORDER	CHANGES								
DATE	STEP		PROCEDURE CHANGE By					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
				· · · · · · · · · · · · · · · · · · ·									
Part No) :		PAR #:	Fault Category:	NCR:	: Yes	No DQ	A:	_ Date: _				
Resolution:				Disposition:				QA: N/C Closed: Date:					
NCR:	WORK ORDER NON-CONFORMANCE (NCR)												

NCR:		R: WORK ORDER NON-CONFORMANCE (NCF						
		Description of NC Corrective Action Section B			Verification Approv	Approval	Approval	
DATE	STEP	Section A	Initial Action Description Sign & Chief Eng Chief Eng Date		Section C	Chief Eng	QC Inspector	
							·	
		·						

Work Order ID 73086

Thursday, August 25, 2011 1:25:40 PM



Page 2

Item ID:

D3264-1

Accept

Setup Start

Stop



Revision ID:

Item Name: Start Date:

Bracket

8/25/2011

Start Qty: 6.00

Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date:_____

Tooling:

Date:

Run Start

Required Date: 9/5/2011

Date:

SPC (Y/N):

Set Up/

Run Hours

Tool 1D

Date:

Stop

Sequence ID/ **Work Center ID**

120

QC

Quality Control

Operation Description

QC2- Inspect parts off machine FAI/FAIB

0.00

and 11/09/07

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

QC8- Inspect parts - second check

Memo

0.00

0.00

0.00

≥ 11. 9. 7

QC

Memo

Chemical Conversion Coat per QSI005 4.1

Quality Control

140

130

Hand Finishing

HandFinish

Memo

0.00

6XD m/24/09/08

Dart Aerospace Ltd

	oopaoc									
W/O:			W	ORK ORDER CHANGE	S					
DATE	STEP	PRO	CEDURE CH	ANGE		Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
·							· · · · · · · · · · · · · · · · · · ·			
						:				
Part No	•	PAR #:	Fault Cat	tegory:	NCR:	Yes N	o DQA	٨:	_ Date: _	
_	R	esolution:	Dispositi	on:	QA: N	VC Clos	ed:		Date: _	
NCR:		V	VORK ORI	DER NON-CONFORMA	NCE (NCR)				
DATE	OTED	Description of NC		Corrective Action Section			Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC inspector
									:	
		4-5								
						•				
	-			·		 				

Work Order ID 73086



Page 3

Thursday, August 25, 2011 1:25:40 PM

Item ID:

D3264-1

Accept



Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

8/25/2011

Bracket

Start Qty: 6.00

Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Required Date: 9/5/2011

Process Plan:

Operation

Description

Date:

Tooling:

Date:

Date:

Run

Start

Stop



Date:

SPC (Y/N):

Set Up/

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Work Center ID 150

Sequence ID/

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Powdercoat

Powder Coating

Memo

Run Hours

0.00 Start (ime: 1:00) 0.00 Temp : 3200F Finish Time: 1:30

160

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

170

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

Dart Ae	rospace	e Ltd								
W/O:			W	ORK ORDER CHANGE	ES					
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									į	
	-	·								
Part No):	PAR #:	Fault Cat	tegory:	NCR:	Yes N	o DQA :		_ Date: _	
	R	esolution:	Disposit	ion:	QA: N	I/C Clos	sed:		Date: _	
NCR:	,		WORK ORI	DER NON-CONFORMA	NCE (NCR)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng		Sign & Date	Verifica Section		Approval Chief Eng	Approval QC inspector
	†					•				

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC	Description of NC Corrective Action Section B				Verification Approval	Approval	
DATE STEP Description of NC Section A			Initial Action Description Sign & Chief Eng Chief Eng Date		Section C				
							·		
			,						

Work Order ID 73086

Thursday, August 25, 2011 1:25:40 PM



Page 4

Item ID:

D3264-1

Accept

Setup Start

Stop

Start

Stop



Revision ID:

Start Date:

Item Name:

Bracket

8/25/2011

Start Qty: 6.00

Required Date: 9/5/2011 **Req'd Qty:** 6.00 Date:

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

QC:

Operation

Description

Date: _____

SPC (Y/N):

Tooling:

Set Up/

Run Hours

Tool ID

Date:

Date:_

Tool # Plan Code

Accept Qty

Reject Qty

Run

Reject Insp. Number

Stamp

180

Sequence ID/

Work Center ID

Quality Control

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

Dart Aerospace Ltd

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W/O:			WO	RK ORDER CHANGE	ES				i,
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							,		
Dord No.	1				NOD V				
Part No		PAR #:							
	R	esolution:						Date: _	
NCR:		'	WORK ORDE	R NON-CONFORMA	NCE (NCF	R)			
DATE	CTED	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	k Secti		Chief Eng	QC Inspector
	,								
						1			
		,							
	1							1	1

Picklist Print

Thursday, August 25, 2011 1:25:37 PM

Work Order ID: 73086

Parent Item:

D3264-1

Parent Item Name: Bracket



Start Date: 8/25/2011

Required Date: 9/5/2011

Start Qty: 6.00

Required Qty: 6.00

Page 1

Comments:

A□04.09.02□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X04.50		Durchased	No				f	7 1167		<u> </u>			

6061-T6 Bar 1.25 X 4.50

Location

MAT004

112628

Loc Qty

7.1167 7.1167 Loc Code

Dart Aerospace Ltd

Dail Ac	Ospace	; Llu							
W/O:		,	V	ORK ORDER CHANGE	ES				
DATE	STEP	PROC	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		-							
1				·					
Part No	:	PAR #:	Fault Ca	tegory:	NCR: Ye	es No I	DQA:	Date: _	
	R	esolution:	Disposit	ion:	QA: N/C	Closed:		Date: _	
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (N	CR)			
		Description of NC		Corrective Action Section	Section B Veri			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	: 0	Section C	Chief Eng	QC Inspector
						•			
					1				

DART AEROSPACE LTD	Work Order: 1	73086
Description: Bracket	Part Number:	D3264-1
Inspection Dwg: D3264 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	3 688			Vern Mc	06
0.063	+/-0.010	.062			((
0.125	+/-0.010	, 122			, ,	
0.875	+0.010/-0.020	. 873			16	
0.062	+/-0.010	* 0 le 1			ŧ,	
R0.03	+/-0.030	R,036			R-L	
R0.13	+/-0.030	R.130	_		16	
1.00	+/-0.030	1,000			Vern nl	-0 i
0.125	+/-0.010	.125			i (
0.600	+/-0.010	. 600			"	
4.000	+/-0.005	4.000	· 		٠(
0.750	+/-0.010	+750			11	
Ø0.194	+0.005/-0.000	\$.195	1			
5.50	+/-0.030	5.500			11	
0.125	+/-0.010	.125			1 (
0.063	+/-0.010	:064			1.	
R0.25	+/-0.030	R.250			R-L	
4.27	+/-0.030	4.272			R-L Hern M	1-06
R0.30	+/-0.030	R.300			R-6	

Measured by:	one	Audited by:			Prototype Approval:	N/A	
Date:	1/09/07	Date:	11.	9	. 7	Date:	N/A

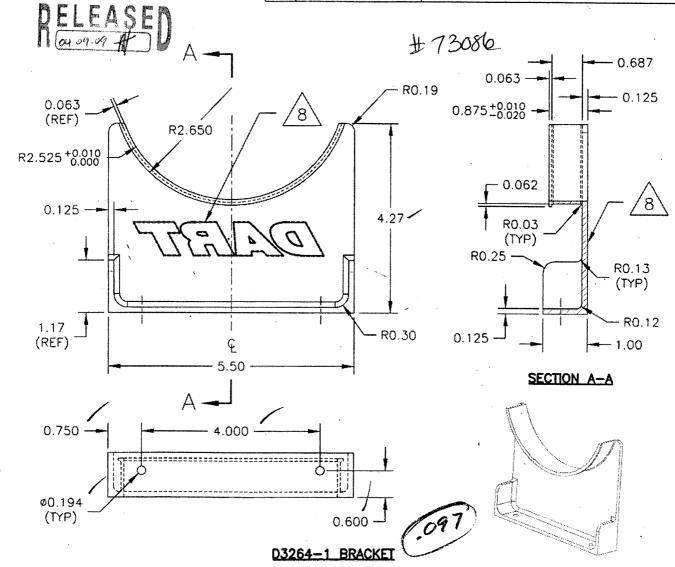
Rev	Date	Change	Revised by	Approved
Α	04.09.03	New Issue	KJ/JLM	
В	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM ,	
С	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	N.
-				-

Dart Ae	rospace l	Ltd							-
W/O:			WOR	K ORDER CHANG	SES		· · · ·		
DATE STEP PR			CEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #: solution:							
NCR:		,	WORK ORDER	R NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial , Chief Eng	Action Description Chief Eng				Approval Chief Eng	Approval QC Inspector
	4								





DESIG	神	DRAWN BY	1	SPACE LTD INTARIO, CANADA
CHECK	ED #	APPROVED -	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE	······		TITLE	SCALE
04.0	4.20		BRACKET	1:2
Α		04.04.20	NEW ISSUE	



D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER 8) ENGRAYE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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W/O:			* .							
DATE	STEP	PRO	OCEDURE CHA	ANGE		Ву	Date	Approval Chief Eng / Prod Mgr	Ap, QC In	
			. * ·							
							•			
					. 4					
									. "	
					• •			<u> </u>		
Part No:		PAR #:	Fault Cate	egory:	NC	R: Yes	No DQ	_ Date: _		
	Re	esolution:	Disposition	on:	QA	: N/C C	losed:		Date: _	
NCR:				ER NON-CONFO						
DATE	STEP	Description of NC	Corrective Action Section B				Verifi	Verification	Approval	Approval
DAIE	SIEP	Section A	Initial Chief Eng	Action Descrip	otion	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
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